

Work Order ID 68501



Page 1

Thursday, April 14, 2011 10:16:35 AM

Item ID: D4055-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Aft End

Start Date: 4/14/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 4/10/11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4055

Prog rev: B

Dwg rev: A

1311-5-4

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1311-5-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

(2)

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Page 2

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00		SB 11/05/09		(2)			
140 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		Simor 11/05/09		(72)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		11.05.09		2	0		

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

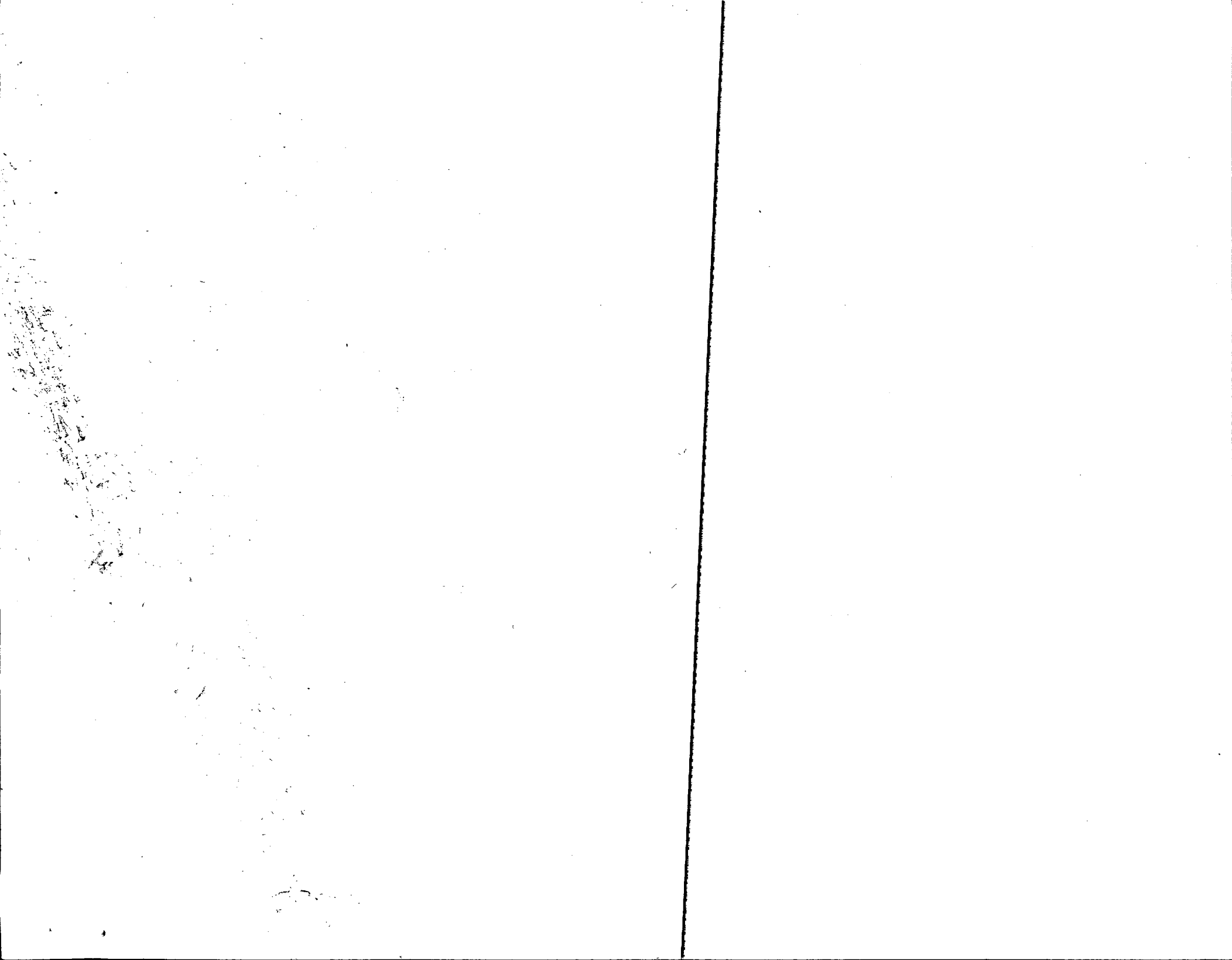
Memo

0.00

Quality Control

11/5/10

11-05-9
②



Picklist Print

Thursday, April 14, 2011 10:16:32 AM

Page 1

Work Order ID: 68501

Parent Item: D4055-3

Parent Item Name: Tank Aft End



Start Date: 4/14/2011

Required Date: 4/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	373.0000	1.5143	3.188			



6061-T6 .063 Sheet



B11-5-4

Location

Loc Qty

Loc Code

MAT021

373

113608

1

116308

36

117285

336

117285

(2)

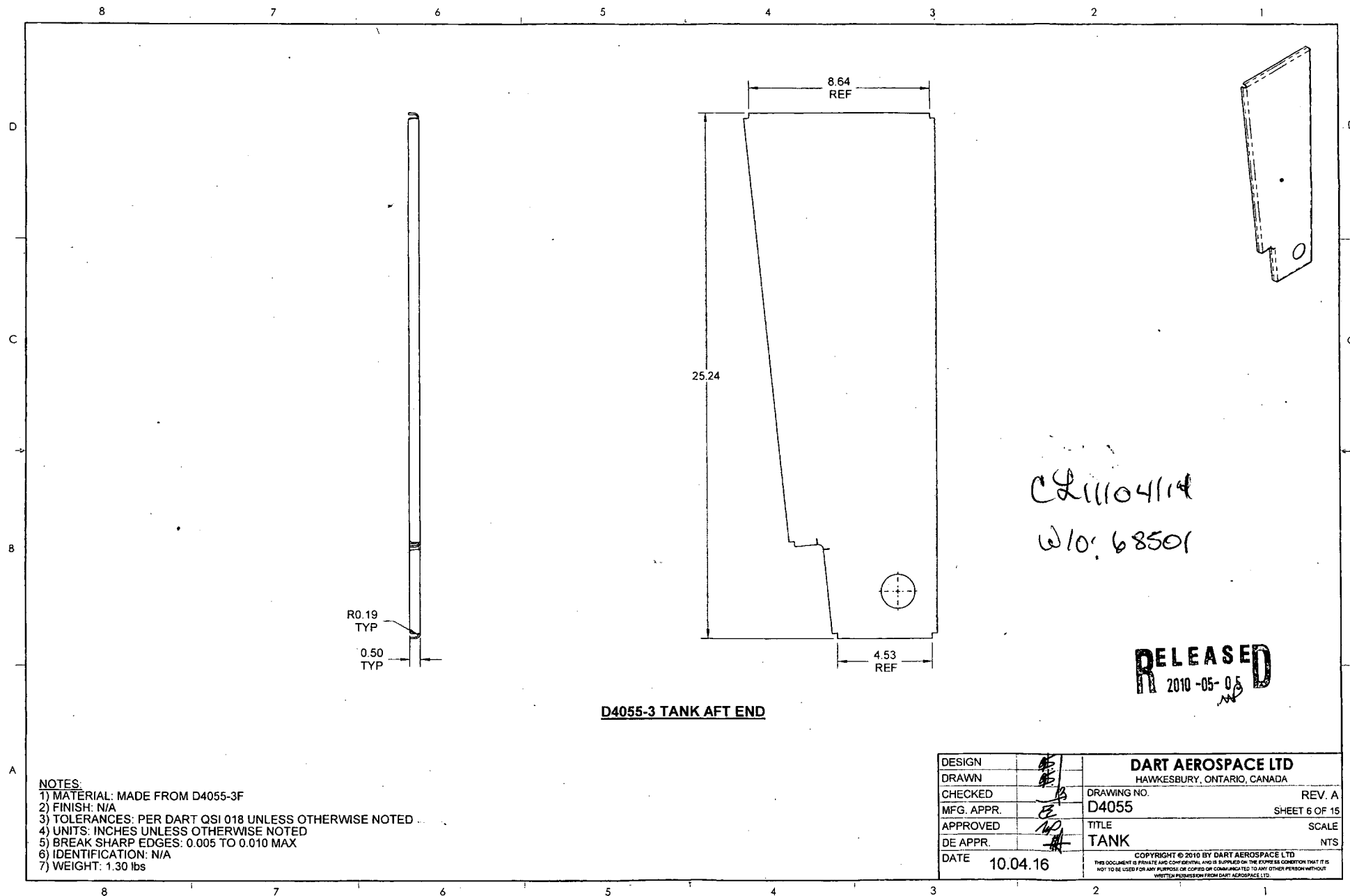
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

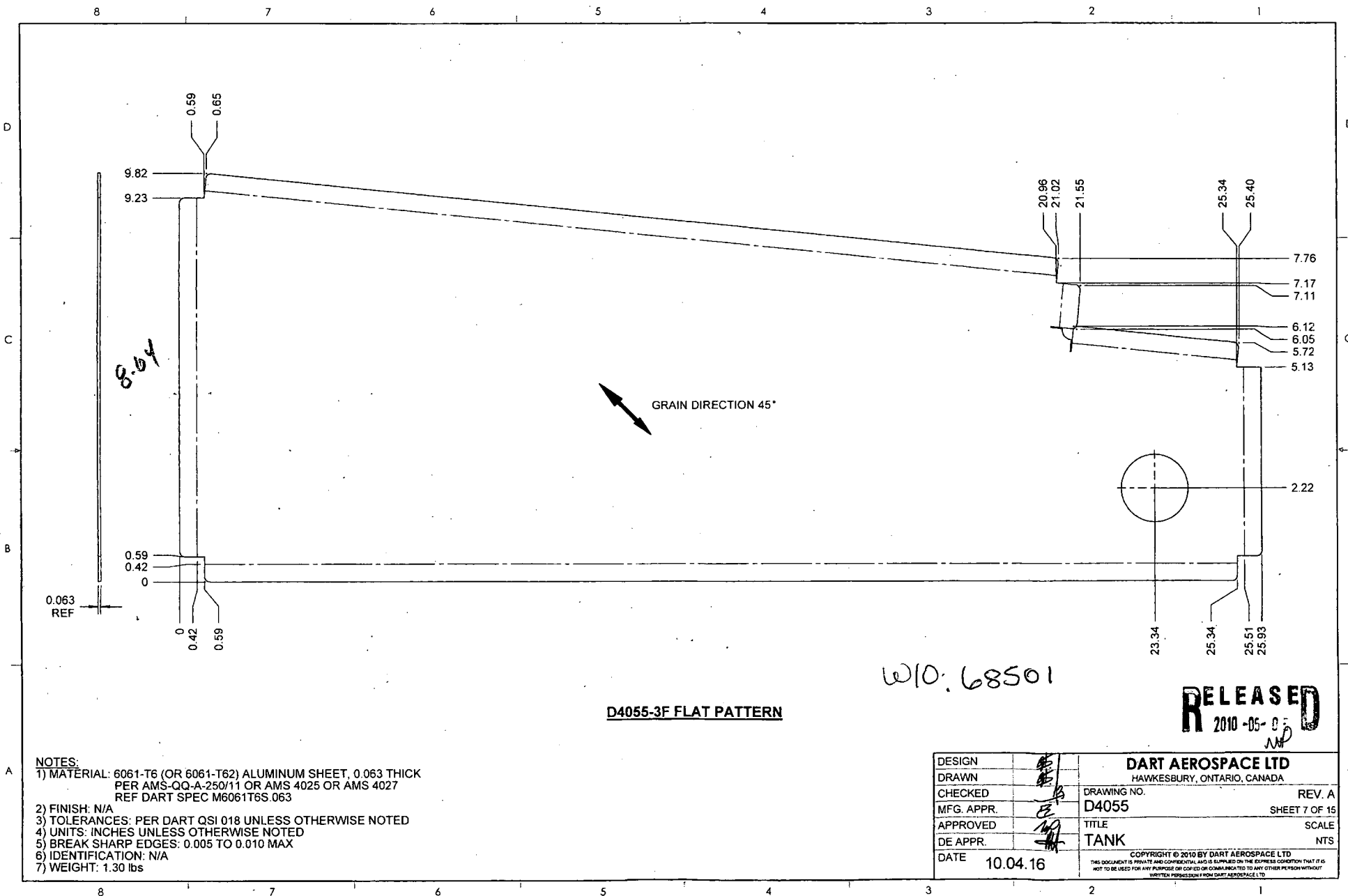
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DART AEROSPACE LTD		Work Order:	68501
Description: Tank Aft End		Part Number:	D4055-3
Inspection Dwg: D4055 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.42	+/-0.030	BEND LINE			V 1802	
0.59	+/-0.030	.597	x		V	
9.23	+/-0.030	9.23	x		T 1801	
9.82	+/-0.030	9.82	x		T	
0.59	+/-0.030	.597	x		V	
0.65	+/-0.030	.65	x		V	
23.34	+/-0.030	23.34	x		T	
25.34	+/-0.030	25.34	x		T	
25.51	+/-0.030	BEND LINE			T	
25.93	+/-0.030	25.93	x		T	
2.22	+/-0.030	2.222	x		V	
5.13	+/-0.030	5.126	x		V	
5.72	+/-0.030	5.722	x		V	
6.05	+/-0.030	6.05	x		V	
6.12	+/-0.030	6.121	x		V	
7.11	+/-0.030	7.11	x		V	
7.17	+/-0.030	7.17	x		V	
7.76	+/-0.030	7.762	x		V	
20.96	+/-0.030	20.96	x		T	
21.02	+/-0.030	21.02	x		T	
21.55	+/-0.030	21.55	x		T	
25.34	+/-0.030	25.34	x		T	
25.40	+/-0.030	25.40	x		T	
0.063	+/-0.010	.060	x		V	

Measured by:	B	Audited by:	S	Preliminary Approval:	
Date:	11-5-4	Date:	11/07/05	Date:	

Rev	Date	Change	Revised by	Approved
A	11.01.18	New Issue	KJ	

